

Work Order ID 101922

May-21-13 3:31:08 PM

101922

Page 1

Item ID: D3955-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover Plate

Stop

NS2

Start Date: 5/21/13

Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/04/13

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: HLJ

Date: 13-05-22 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3955 | A |

100 0.00

100

Waterjet

Memo

0.00

12 0 JM13-6-4

FLOW CNC Waterjet

304,063

1-Cut as per Dwg D3955:

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

12 0 JM13-6-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

| Work Order: _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------------------------|---------|------|-----|---|--|--|--|--|--------------|--|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |
| Part No. _____ NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | General | | | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | |
| Centre Not Concentric to O/S | | | | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | |
| Cracks | | | | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | |
| Crushed/Crimped | | | | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | |
| Cuffs | | | | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | |
| Heat Treat | | | | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | |
| Inspection Strip in Tube | | | | Cut Too Short <input type="checkbox"/> | Misread <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | |
| Ripples in Bend | | | | Drill Holes <input type="checkbox"/> | Offset <input type="checkbox"/> | | | | | | |
| Torque Waves in Extrusion | | | | Drawing <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | |
| Turning Sequence | | | | Finish <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | |
| Wave/Twist in Tube | | | | Folio <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | |
| | | | | | | Other <input type="checkbox"/> | | | | | |

Work Order ID 101922

May-21-13 3:31:08 PM

101922

Page 2

Item ID: D3955-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover Plate

Start Date: 5/21/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/04/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

QAS

0.00

221

12

130

130

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 125341.00

0.00

Memo

0.00

12 4 113-64

140

140

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

12 4 113-64

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | |
|---|------|------|---|---|---------------------------------------|---|---|-------------|--------------|--------------|--|--|---|--|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

Work Order ID 101922

May-21-13 3:31:08 PM

101922

Page 3

Item ID: D3955-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Cover Plate

Stop

NS2Start Date: 5/21/13 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 6/04/13 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: 51079

0.00

0.00

L 12X 11.10.13-06-5

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*13/6/10 AD**MC-act*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------------------------|------------------------------|--------------------------|---|--|--|--|---------------------------------|--------------------------|--------------------|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | |
| Part No. _____ NCR No. _____ | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | General | | | | | | | | | |
| | Bending | <input type="checkbox"/> | Bend | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Ovalized | <input type="checkbox"/> | Pressure/Forced | |
| | Centre Not Concentric to O/S | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Temperature/Cure | |
| | Cracks | <input type="checkbox"/> | Broken/Damaged | <input type="checkbox"/> | Inspection Incomplete | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Weld | |
| | Crushed/Crimped | <input type="checkbox"/> | Burrs | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Wrong Stock Pulled | |
| | Cuffs | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Maintenance | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | | |
| | Heat Treat | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | | |
| | Inspection Strip in Tube | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Power Loss/Surge | <input type="checkbox"/> | Other | |
| | Ripples in Bend | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Offset | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| | Torque Waves in Extrusion | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| Turning Sequence | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | | <input type="checkbox"/> | | | |
| Wave/Twist in Tube | <input type="checkbox"/> | Folio | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | | <input type="checkbox"/> | | | |

Picklist Print

May-21-13 3:31:11 PM

Page 1

Work Order ID: 101922

101922
D3955-3

Parent Item: D3955-3

Parent Item Name: Cover Plate

Start Date: 5/21/13

Required Date: 6/04/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|---------|
| M304S16GA | | Purchased | No | | | 100 | sf | 453.8742 | 0.3553 | 4488 | ** | 4.5 | Jm136-4 |

M304S16GA

304/316 Sheet .063

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT020 | 453.8741688 | |
| 122245 | 0.1713688 | |
| 123136 | 140.8 | |
| 124428 | 28.35 | |
| 124572 | 28.5528 | |
| 125599 | 256 | 125599 |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------------------------|------------------------------|--------------------------|---|--|--|--|---------------------------------|--------------------------|--------------------|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | |
| Part No. _____ NCR No. _____ | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | General | | | | | | | | | |
| | Bending | <input type="checkbox"/> | Bend | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Ovalized | <input type="checkbox"/> | Pressure/Forced | |
| | Centre Not Concentric to O/S | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Temperature/Cure | |
| | Cracks | <input type="checkbox"/> | Broken/Damaged | <input type="checkbox"/> | Inspection Incomplete | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Weld | |
| | Crushed/Crimped | <input type="checkbox"/> | Burrs | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Wrong Stock Pulled | |
| | Cuffs | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Maintenance | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | | |
| | Heat Treat | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | | |
| | Inspection Strip in Tube | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Power Loss/Surge | <input type="checkbox"/> | Other | |
| | Ripples in Bend | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Offset | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| | Torque Waves in Extrusion | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| | Turning Sequence | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | | <input type="checkbox"/> | | |
| | Wave/Twist in Tube | <input type="checkbox"/> | Folio | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | | <input type="checkbox"/> | | |

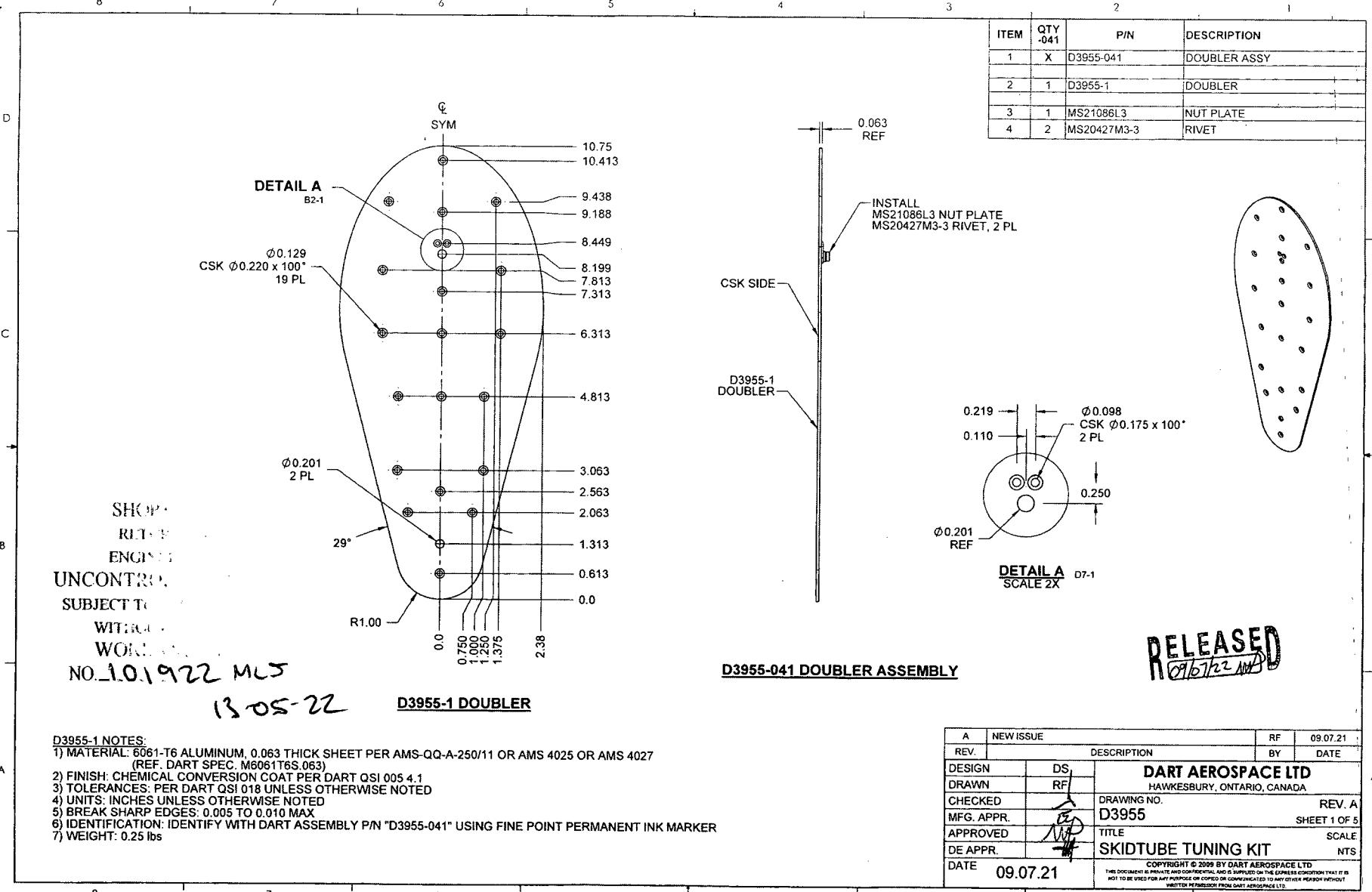
| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 101977 |
| Description: Cover Plate | Part Number: | D3955-3 |
| Inspection Dwg: D3955 Rev: A | | Page 1 of 1 |

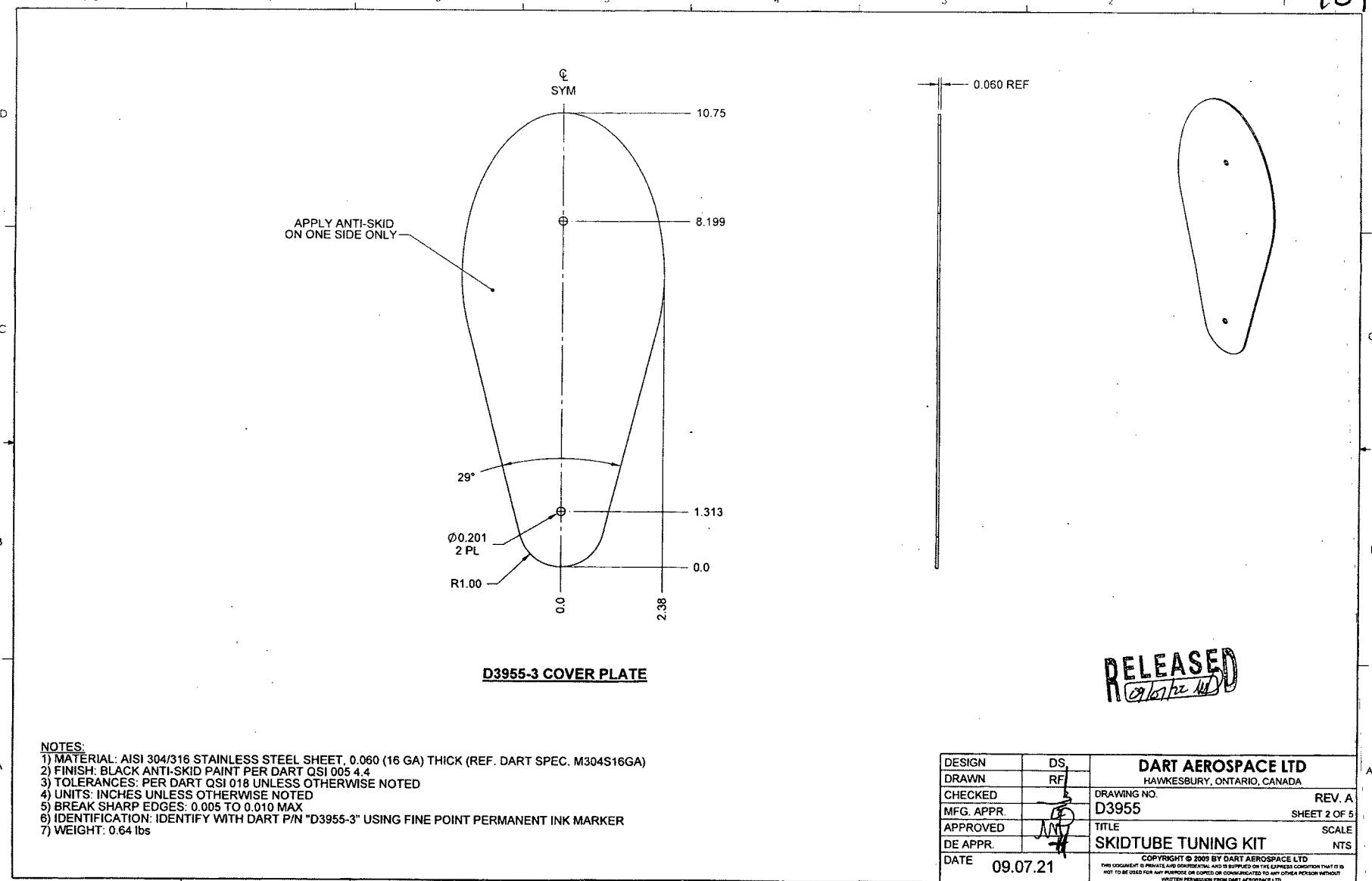
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|--------|-------------|-----------|---------------------|-----|
| Measured by: | JM | Audited by: | DAS 27 | Prototype Approval: | N/A |
| Date: | 13-6-3 | Date: | B64 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 09.07.29 | New Issue | KJ | [Signature] |



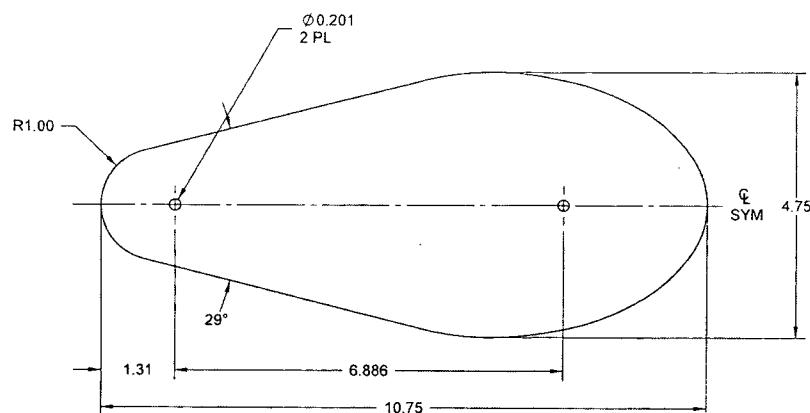


RELEASED
07/01/22

| | | | |
|------------|--------------------|-----------------------------|--|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | |
| MFG. APPR. | <i>[Signature]</i> | REV. A | |
| APPROVED | <i>[Signature]</i> | D3955 | |
| DE APPR. | <i>[Signature]</i> | SHEET 2 OF 5 | |
| DATE | 09.07.21 | TITLE | |
| | | SKIDTUBE TUNING KIT | |
| | | SCALE | |
| | | NTS | |

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101922



D3955-X PLATE

| General Table | | | |
|---------------|--------|--------|--------------|
| P/N | T (in) | T (GA) | WEIGHT (lbs) |
| D3955-5 | 0.060 | 16 | 0.64 |
| D3955-7 | 0.120 | 11 | 1.28 |

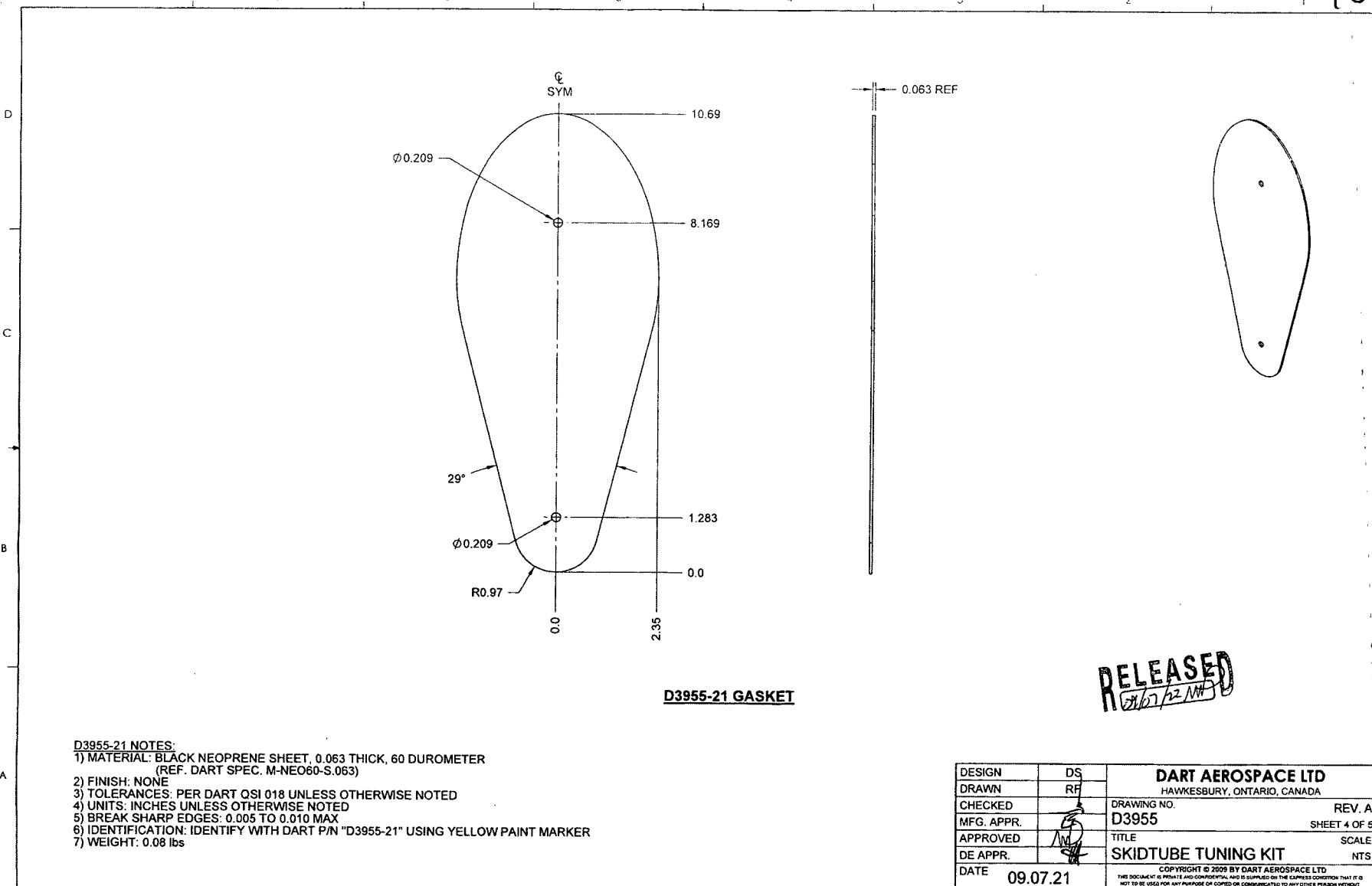
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

| | | | |
|------------|-----------|---|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>✓</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>EP</i> | D3955 | SHEET 3 OF 5 |
| APPROVED | <i>ND</i> | TITLE | SCALE |
| DE APPR. | <i>#</i> | SKIDTUBE TUNING KIT | NTS |
| DATE | 09.07.21 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

RELEASED
06/02/2021 MD

101922



| | | | |
|---------------|----|-----------------------------|--|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | REV. A | |
| MFG. APPR. | | DRAWING NO. D3955 | |
| APPROVED | | SHEET 4 OF 5 | |
| DE APPR. | | TITLE SKIDTUBE TUNING KIT | |
| DATE 09.07.21 | | SCALE NTS | |

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RELEASED
09.07.21 MHD

LO1922

